Work Order ID 112085

January-29-14 9:27:40 AM

112085

Item ID: D4635-3
Revision ID:
Item Name: Aft Ceiling Panel, LH
Start Date: 30/01/2014 **Start Qty:** 1.00 *1*
Required Date: 24/02/2014 **Req'd Qty:** 1.00 *1*
Reference:

Accept *N900040100*

Setup **Start** *NS1*
Stop *NS2*

Cust Item ID:
Customer:

Approvals: **Process Plan** AH **Date:** 14-01-29
QC: _____ **Date:** _____

Tooling: _____ **Date:** _____
SPC (Y/N): _____ **Date:** _____

Run **Start** *NR1*
Stop *NR2*

Draw Nbr	Revision Nbr
D4635	E

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
100	HAND FINISHING THERMOFORMING	0.00							
100						x1			DL
Thermoform	**Memo**	0.00							14/03/01
Thermoforming Machine	Cut Blanks								
105	Dry Material	0.00							
105						x1			DL
HandThermo	**Memo**	0.00							14/02/01
Hand Finishing Thermoforming	Dry Sheet as per QSI022 POLYCARBONATE								

Temp: 250°F
Time IN: 5:00 pm 14/01/31
Time OUT: 6:00 am 14/02/01

DQA: _____ Date: _____

DART AEROSPACE

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

☐ Bending
☐ Centre Not Concentric
☐ Cracks
☐ Crimp/Kink/Ripple/Wave
☐ Cuffs
☐ Crushing
☐ Heat Treat
☐ Inspection Strip in Tube
☐ Marks/Chatter
☐ Turning Sequence
☐ Wave/Twist in Tube

General

☐ Bend
☐ BOM/Route
☐ Broken/Damage/Defect
☐ Burrs
☐ Contamination
☐ Countersink
☐ Cut Too Short
☐ Drawing
☐ Drill Holes
☐ Finish
☐ Fit/Function

☐ Folio/Program
☐ Grain
☐ Hardware
☐ Inspection Incomplete/Unqualified
☐ Instructions Incomplete/Unclear
☐ Misaligned/off center
☐ Mislabeled
☐ Misread
☐ Off-set
☐ Out of Calibration
☐ Out of Sequence

☐ Outside Dimensions
☐ Over/Under tolerance
☐ Part Incorrect
☐ Part Lost/Missing
☐ Part Moved
☐ Positioned Wrong
☐ Power Loss/Surge

☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled

☐ Other

Work Order ID 112085

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Revision ID:
Item Name: Aft Ceiling Panel, LH
Start Date: 30/01/2014 **Start Qty:** 1.00 *1*
Required Date: 24/02/2014 **Req'd Qty:** 1.00 *1*
Reference:

Accept *N9000040100*

Setup Start *NS1*
Stop *NS2*

Cust Item ID:
Customer:

Run Start *NR1*
Stop *NR2*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110		0.00							
110	THERMOFORMING MACHINE					X1			DL 14/02/01
Thermoform	**Memo**	0.00							
Thermoforming Machine	Thermoform as per Dwg. D4635-3 and Folio FTA149								
	Dwg. Rev. E								
	Folio Rev. D								
	Visually inspect for proper formation and texture								
130		0.00							
130	HAND FINISHING THERMOFORMING					X1			JB 14/03/11
Thermoform	**Memo**	0.00							
Thermoforming Machine	Trim to Finished Dimensions								
140	~~QC~~ - Inspect dimensions to drawing	0.00							
140 QC5	Dimensional Inspection								
QC	**Memo**	0.00							
Quality Control S	Fill out Inspection Sheet Rev A	DAS 16 9-89 14/03/14							

DQA: _____ Date: _____

DART AEROSPACE

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

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Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

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Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
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Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐ ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
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Handling/Pre	☐									
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Supplier	☐									
Training	☐									
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Cust Item ID:
Customer:

Run Start *NR1*
Stop *NR2*

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QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC5- Inspect part completeness to step on W/O	0.00							
150									
QC	**Memo** N/A	0.00							
Quality Control									
160		0.00							
160	Packaging								
Packaging	**Memo** med fab	0.00				①	SAD 14/03/14		
Packaging									
170	QC21- Final Inspection - Work Order Release	0.00							
170									
QC	**Memo**	0.00					14-03-14		
Quality Control									

MF 14-3-14

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

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Use-as-is ☐
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Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
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Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

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☐ Power Loss/Surge
☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled
☐ Other _____

Picklist Print

January-29-14 9:27:44 AM

Work Order ID: 112085 *112085*

Parent Item: D4635-3 *D4635-3*

Parent Item Name: Aft Ceiling Panel, LH

Start Date: 30/01/2014 **Required Date:** 24/02/2014

Start Qty: 1.00 **Required Qty:** 1.00

Comments: IPP Rev. A New Issue 12/05/07 DL VERIFIED BY:JLM IPP Rev. B Dwg. Update 12/11/08 DL IPP Rev C Dwg. Ulpdate 13/07/09 DL IPP Rev. D Dwg. Update, Material Change 13/12/18 DL

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MLEXS.093-F6006-07		Purchased	No			100	sf	1,385.760	9.39	10			
MLEXS.093-F6006-07									**				
GE PLASTICS LEXAN SHEET													

Location	Loc Qty	Loc Code	
MAT023	1385.76		
114459	229.26		
123105	38		
124501	1118.5		10 sq ft

DL 14/03/03

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
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Doc/Data	☐									
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Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

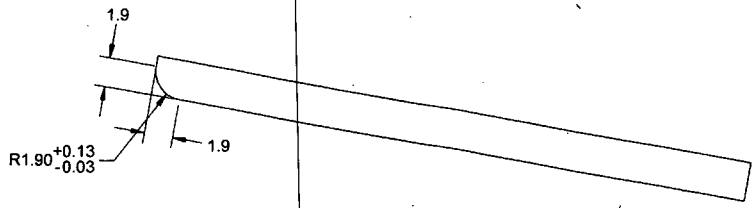
FAULT CATEGORY

Landing Gear

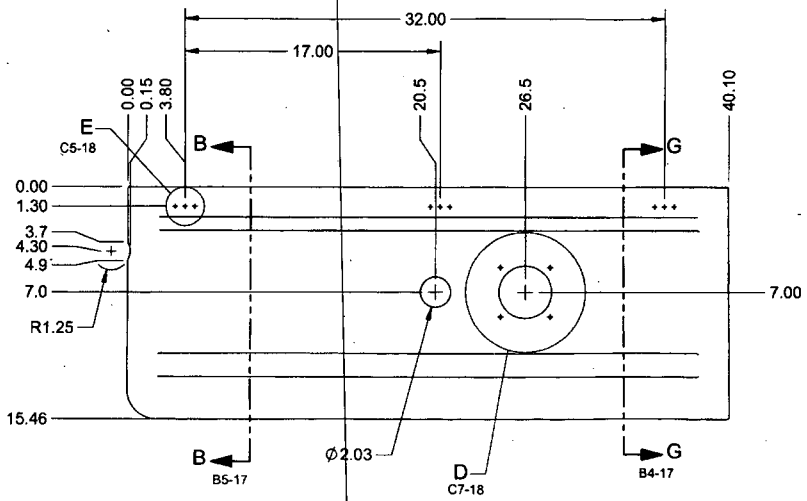
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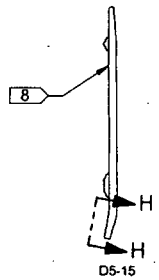
General

☐ Bend
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☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled
☐ Other _____



SECTION H-H B2-15





17085 MD
14-01-29

RELEASED
2014 -01- 22

NOTES:
1) MATERIAL: F6006 SUEDE/POLISHED GY5B133 LIGHT GREY LEXAN SHEET 0.093 THICK
(REF DART SPEC MLEXS.093-F6006-07)
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 2.66 lbs
8) TEXTURE ON THIS SIDE
9) TRIM D4635-3 PER TOOL DT9841
10) THERMOFORM D4635-3 PER QSI 022 USING DT9849 TOOL
MIN. THICKNESS AFTER FORMING:
RIDGES/EDGES = 0.060
ELSEWHERE = 0.070

D4635-3 LH, AFT CEILING PANEL

DESIGN	RF	**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
DRAWN	RF	DRAWING NO. REV. E
CHECKED		D4635 SHEET 15 OF 18
MFG. APPR.		TITLE SCALE
APPROVED		OUTBOARD CEILING PANELS NTS
DE APPR.		
DATE	14.01.09	

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DQA: _____ Date: _____

DART AEROSPACE

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐ ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
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Operator	☐									
Offset/Setup	☐									
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Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

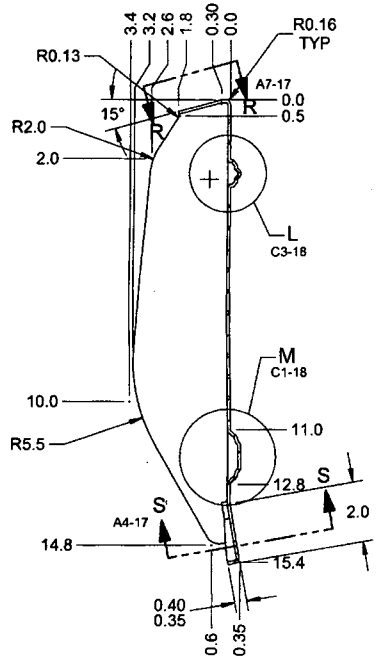
FAULT CATEGORY

Landing Gear

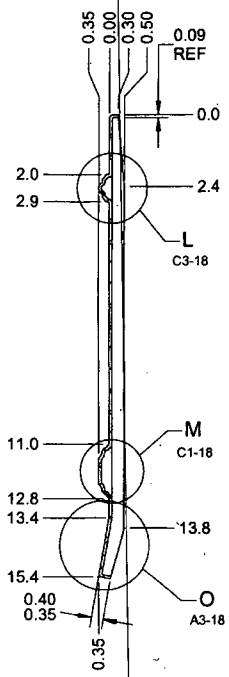
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☐ Heat Treat
☐ Inspection Strip in Tube
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General

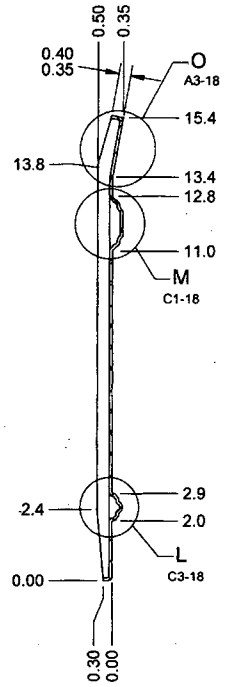
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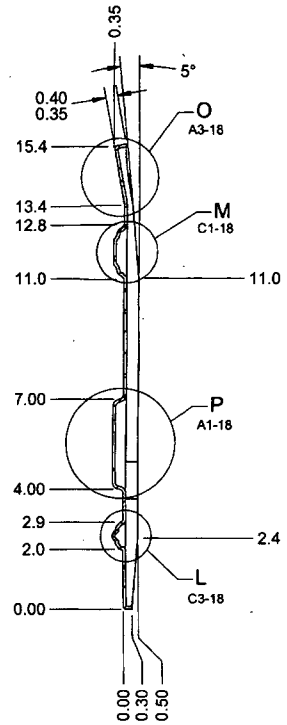
SECTION A-A
SECTION A'-A' OPPOSITE B3-13 B3-14
SCALE 2X



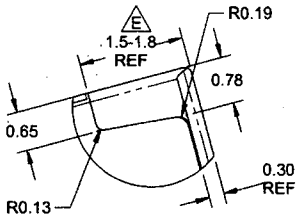
SECTION B-B B7-13 B7-14
SCALE 2X



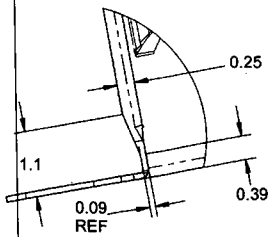
SECTION G-G B4-15 B4-16
SCALE 2X



SECTION K-K C6-16
SCALE 2X



AUXILIARY VIEW R-R
SECTION R'-R' OPPOSITE D7-17
SCALE 2X



AUXILIARY VIEW S-S
SECTION S'-S' OPPOSITE B7-17
SCALE 2X

RELEASED
2014-01-22

DESIGN	RF	**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
DRAWN	RF	DRAWING NO. D4635 REV. E
CHECKED		SHEET 17 OF 18
MFG. APPR.		TITLE OUTBOARD CEILING PANELS SCALE NTS
APPROVED		
DE APPR.		
DATE	14.01.09	

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DART AEROSPACE

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Process	☐									
Supplier	☐									
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Transport	☐									
Unapproved	☐									

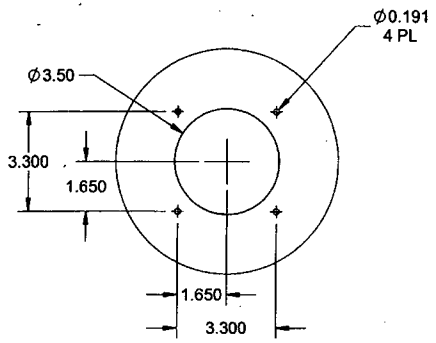
FAULT CATEGORY

Landing Gear

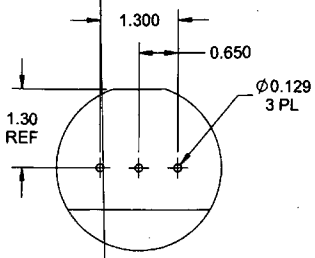
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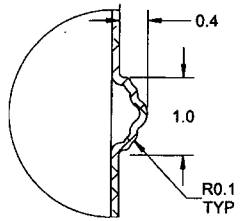
☐ Bend
☐ BOM/Route
☐ Broken/Damage/Defect
☐ Burrs
☐ Contamination
☐ Countersink
☐ Cut Too Short
☐ Drawing
☐ Drill Holes
☐ Finish
☐ Fit/Function
☐ Folio/Program
☐ Grain
☐ Hardware
☐ Inspection Incomplete/Unqualified
☐ Instructions Incomplete/Unclear
☐ Misaligned/off center
☐ Mislabeled
☐ Misread
☐ Off-set
☐ Out of Calibration
☐ Out of Sequence
☐ Outside Dimensions
☐ Over/Under tolerance
☐ Part Incorrect
☐ Part Lost/Missing
☐ Part Moved
☐ Positioned Wrong
☐ Power Loss/Surge
☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled
☐ Other



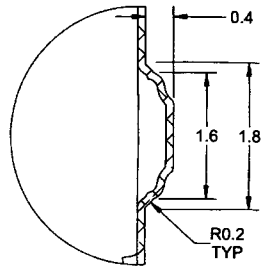
DETAIL D B4-13, B3-14, B5-15, B5-16
SCALE 2X



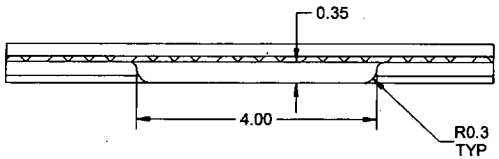
DETAIL E C7-13, B6-14, C6-15, B5-16
SCALE 4X



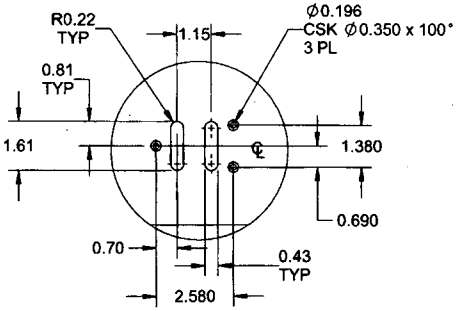
DETAIL L B2-17, B4-17, C5-17, C7-17
SCALE 1.5X



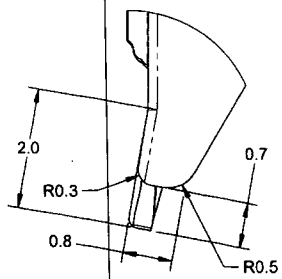
DETAIL M C2-17, C3-17, C5-17, C7-17
SCALE 1.5X



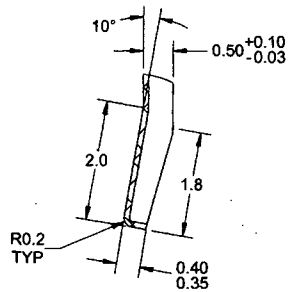
SECTION I-I B5-16
SCALE 4X



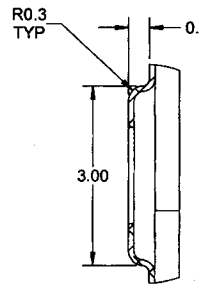
DETAIL Q C5-16
SCALE 2X



DETAIL N B2-13
SCALE 2X



DETAIL O D2-17, D3-17, B5-17
SCALE 2X



DETAIL P C2-17
SCALE 4X

RELEASED
2014-01-22

DESIGN	RF	**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
DRAWN	RF	DRAWING NO. D4635 REV. E
CHECKED	SC	SHEET 18 OF 18
MFG. APPR.		TITLE OUTBOARD CEILING PANELS SCALE NTS
APPROVED		
DE APPR.		
DATE	14.01.09	

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DQA: _____ Date: _____

DART AEROSPACE

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐ ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

☐ Bending
☐ Centre Not Concentric
☐ Cracks
☐ Crimp/Kink/Ripple/Wave
☐ Cuffs
☐ Crushing
☐ Heat Treat
☐ Inspection Strip in Tube
☐ Marks/Chatter
☐ Turning Sequence
☐ Wave/Twist in Tube

General

☐ Bend
☐ BOM/Route
☐ Broken/Damage/Defect
☐ Burrs
☐ Contamination
☐ Countersink
☐ Cut Too Short
☐ Drawing
☐ Drill Holes
☐ Finish
☐ Fit/Function

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☐ Weld
☐ Wrong Stock Pulled

☐ Other _____

DART AEROSPACE LTD

Description:	AFT Ceiling Panel LH	**Work Order:**	112085
Inspection Drawing:	H635-3	**Rev:** E	**Part Number:** D4635-3

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
32.00	+/- 0.030	32.00	✓		tape	SFAB-21
17.00	+/- 0.030	17.00	✓		tape	
20.5	+/- 0.100	20.5	✓		tape	
26.5	+/- 0.100	26.5	✓		tape	
7.0	+/- 0.100	7.0	✓		tape	
7.00	+/- 0.030	7.00	✓		tape	SFAB-21
1.300	+/- 0.000	1.300	✓		Vern	SFAB-08
0.650	+/- 0.010	0.660	✓		Vern	
Ø 0.129	+0.007 -0.001	Ø 0.129	✓		Vern	
Ø 3.50	+0.016 -0.004	Ø 3.50	✓		Vern	
Ø 0.191	+0.005 -0.001	Ø 0.191	✓		Vern	
3.300	+/- 0.010	3.306	✓		Vern	
1.650	+/- 0.010	1.650	✓		Vern	
3.300	+/- 0.010	3.306	✓		Vern	
1.650	+/- 0.010	1.650	✓		Vern	
3.80	+/- 0.030	3.80	✓		Vern	SFAB-08

Measured by: SHD	**Checked By:** DAS 16 9-89	**QC inspector:** DAS 16 9-89	**Engineering Approval** (*if necessary*)**:**
Date 14/03/13	**Date** 14/03/14	**Date** 14/03/14	**Date**